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D4148-1
Job Sheet 197670



Part No: D4148-1

Job Qty: 35 pcs

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 8/19/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	35 pcs	8/19/19	8/19/19	0.06	7.54	Waterjet - Flow		2.19/08/24
110	QC 2	35 pcs	8/19/19	8/19/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2.19/08/24
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
							QC 2 - 73		
							QC 2 - 69		
120	QC 8	35 pcs	8/19/19	8/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		

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				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	DAS
				QC 8 - 9	61
				QC 8 - 68	9-89
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Packaging 3-1 - Stock - B4B 35 pcs	8/19/19	0.00 0.00		Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 5080
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	35 pcs	8/19/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89
Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB) Descriptions: 120 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: _____) 160 - QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S11GA	304/316 0.125 Sheet	12.6245 sf (.3607 ea)	100-Waterjet - Flow - 1	5204167	

Job Allocations					
Operation 100-Waterjet - Flow - 1	Component Part M304S11GA	Required 13	Inventory 60	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	drill 0.129Inches + 0.005 - 0.001	0.134 0.128		
2	Fwd Crosstube Lug Plate	0.19Inches + 0.005 - 0.001	0.196 0.190	0.190	
3	Fwd Crosstube Lug Plate	drill 0.380Inches + 0.006 - 0.001	0.386 0.379		
4	Fwd Crosstube Lug Plate	drill 0.257Inches + 0.006 - 0.001	0.263 0.256		
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499		
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910		
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440		
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		
9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440		
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086		
11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400		
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187		
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723		
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300		
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365		
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810		
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890		
19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990		
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740		
21	Fwd Crosstube Lug Plate	0.625Inches ± 0.010	0.635 0.615		
22	Fwd Crosstube Lug Plate	1.982Inches ± 0.010	1.992 1.972		
23	Fwd Crosstube Lug Plate	0.991Inches ± 0.010	1.001 0.981		
24	Fwd Crosstube Lug Plate	0.770Inches ± 0.030	0.800 0.740		
25	Fwd Crosstube Lug Plate	1.540Inches ± 0.030	1.570 1.510		
26	Fwd Crosstube Lug Plate	2.470Inches ± 0.030	2.500 2.440		
27	Fwd Crosstube Lug Plate	0.820Inches ± 0.030	0.850 0.790		
28	Fwd Crosstube Lug Plate	3.570Inches ± 0.030	3.600 3.540		
29	Fwd Crosstube Lug Plate	1.230Inches ± 0.030	1.260 1.200		
30	Fwd Crosstube Lug Plate	0.730Inches ± 0.030	0.760 0.700		
31	Fwd Crosstube Lug Plate	0.125Inches ± 0.010	0.135 0.115		
32	Fwd Crosstube Lug Plate	0.252Inches + 0.030 - 0.000	0.282 0.252		

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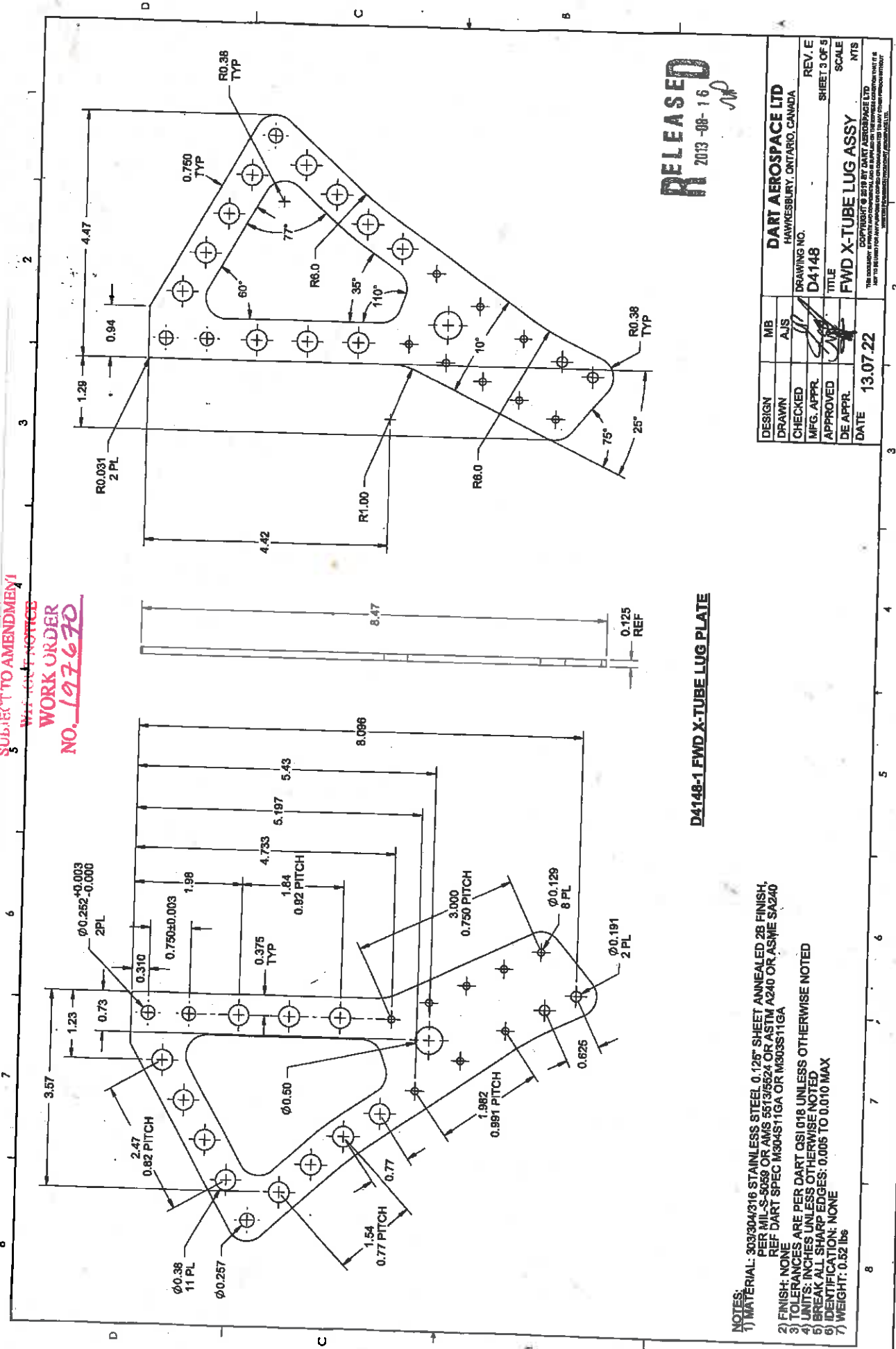
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SUBJECT TO AMENDMENT

WORK ORDER

NO. 197670



RELEASED
2013-08-16

D4148-1 FWD X-TUBE LUG PLATE

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.126" SHEET ANNEALED 2B FINISH, PER MIL-S-9050 OR AMS 5613/5624 OR ASTM A240 OR ASME SA240
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4148
MFG. APPR.		REV. E
APPROVED		SHEET 3 OF 5
DE APPR.		TITLE FWD X-TUBE LUG ASSY
DATE	13.07.22	SCALE NTS

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